

Patent Abstracts of Japan

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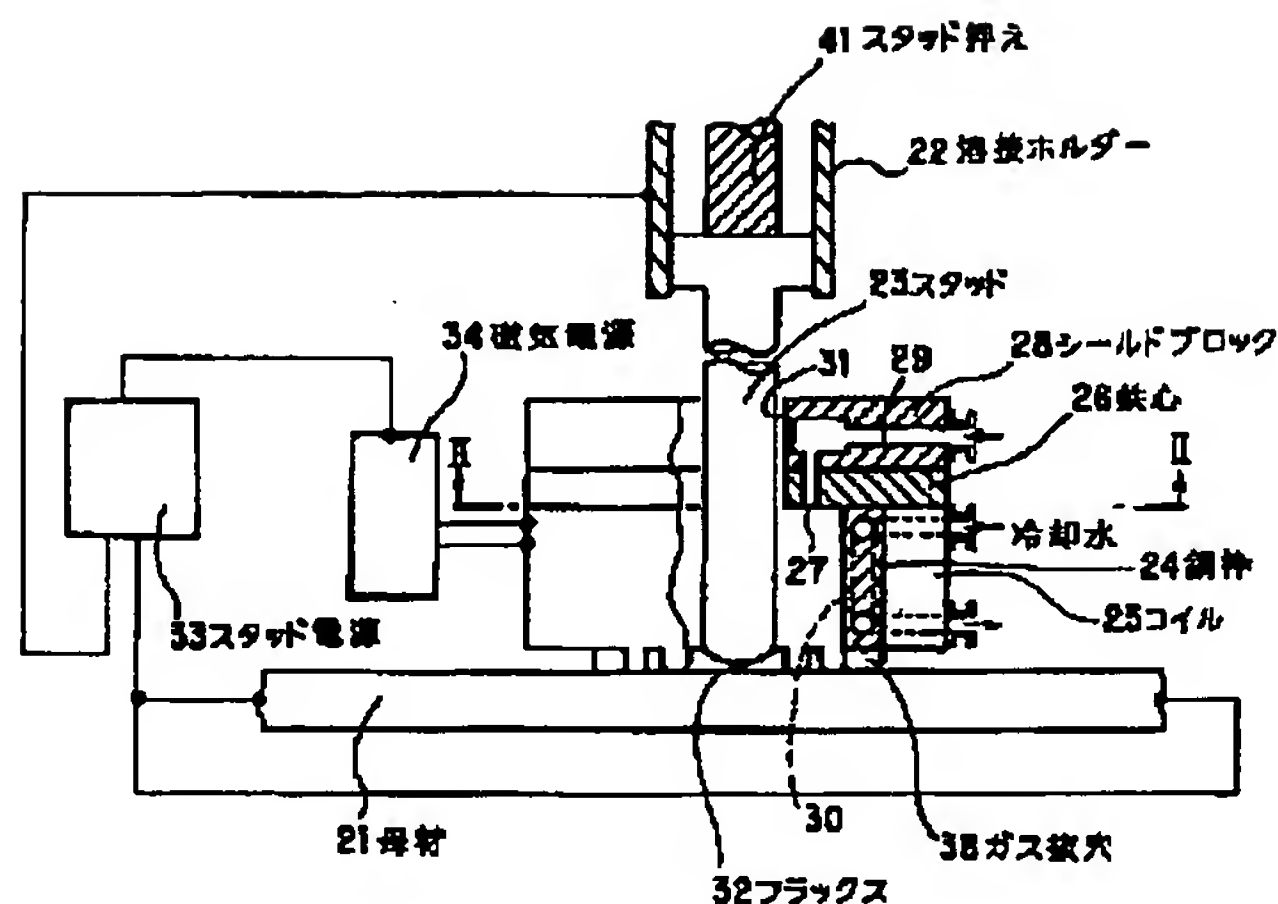
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TITLE : STUD WELDING METHOD AND STUB
WELDING EQUIPMENT



ABSTRACT : PROBLEM TO BE SOLVED: To provide a stud welding method and a stud welding equipment without causing any welding defect with a reduced working hour.

SOLUTION: Shield gas is sent from a communicating hole 29 of a shield block 28 through a communicating hole 27 of a core iron 26 is a weld zone encircled with a copper frame 24, magnetic flux is caused to flow from the tip of a stud 23 toward a base material 21, the intensity of a swelling arc, which is generated by the action of a magnetic field between the stud 23 and the base material 23, is made uniform at the tip of the stud 23, a notched weld zone and the deflection of reinforcement of weld are eliminated, oxidation of a weld zone is prevented. The stud 23, in which the tip is formed to a hemisphere shape and flux 32 is applied, is used, impurity after deoxidation is easily caused to flow out, further, by generating weak arc discharge for long time as the welding current is set to relatively low, welding is conducted, a rust preventive paint, etc., existing on the surface of the base material 21 is evaporated without grinding, generation of a blow hole is prevented. By this method, the welding defect is not caused with a reduced working hour.

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